












File: Monday, 02/02/2009 11:50:32 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT
<b>Job Number</b> : 45401A	
<b>Estimate Number</b> : 10452	
<b>P.O. Number</b> :	<b>Part Number</b> : D32781
<b>This Issue</b> : 02/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3278 REV. C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 44573A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/02/2009 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.02</u>	
<b>Comment</b> : Est:A 04.04.19 New issue KJ/JLM est B 07.09.06 rev.c dwg EC verified by: JLM	
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0	M6061T6B1000X02000
	6061-T6 Bar 1.00 x 2.00
	
	
<b>Comment:</b> Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Batch: <u>110167</u> <u>JLP 09/02/06</u>	
2.0	BAND SAW
	BAND SAW
	
	
<b>Comment:</b> Band Saw Cut blank: 2.00" x 1.00" x 2.550" long <u>JLP 09/02/06</u> (40)	
3.0	HAAS1
	HAAS CNC VERTICAL MACHINING #1
	
	
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1 <u>J.F. 09/02/09</u> (40)	
4.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	
	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>J.F. 09/02/09</u> (40)	
5.0	QC8
	SECOND CHECK
	
	
<b>Comment:</b> SECOND CHECK <u>JK 09/02/09</u> (40)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/02/2009 11:50:32 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 45401A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS

09-02-10

(x40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 109996

START TIME:

13:45

OVEN TEMPERATURE:

320

FINISH TIME:

14:15

BR 09-02-13

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-1

09/02/13

(40X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 80

9/2/06

(40X)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



MF 09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45401
<b>Description:</b> Support		<b>Part Number:</b> D3278-1
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098"	✓			
0.359	+/-0.005	.360"	✓			
0.609	+/-0.010	.613"	✓			
0.250	+/-0.010	.250"	✓			
1.480	+/-0.005	1.480"	✓			
R0.125	+/-0.010	R.125"	✓			
0.119	+0.005/-0.004	.118"	✓			
2.439	+/-0.010	2.439"	✓			
1.980	+/-0.010	1.980"	✓			
R0.13	+/-0.030	R0.130"	✓			
Ø0.257	+0.005/-0.000	Ø.258"	✓			
R0.375	+/-0.010	R.373"	✓			
0.875	+/-0.010	.876"	✓			
0.500	+/-0.010	.504"	✓			
R0.400	+/-0.010	R.400"	✓			
R1.00	+/-0.030	R1.00"	✓			
1.720	+/-0.010	1.722"	✓			
R0.125	+/-0.010	R.125"	✓			
0.125	+/-0.010	.127"	✓			

<b>Measured by:</b> J.F.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/02/09	<b>Date:</b> 09/02/09	<b>Date:</b>	N/A

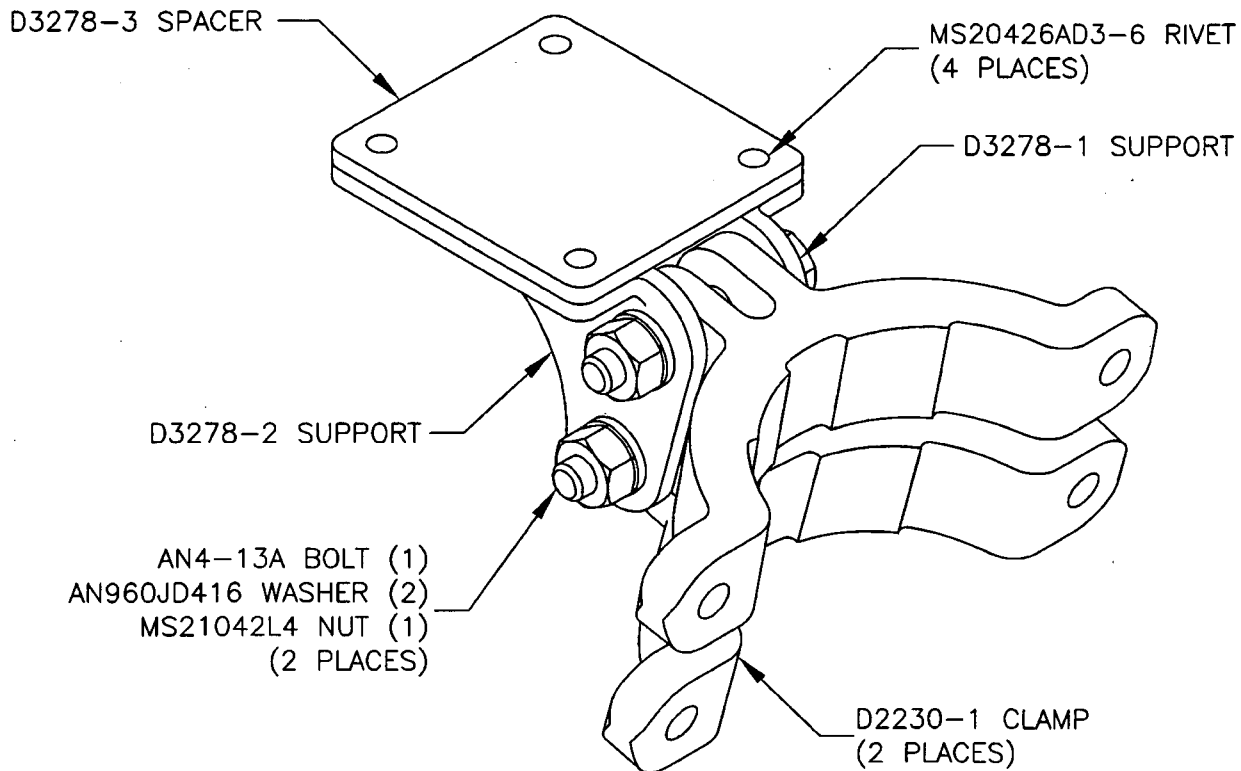
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC [Signature]	[Signature]

**DART**

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07-08-06

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

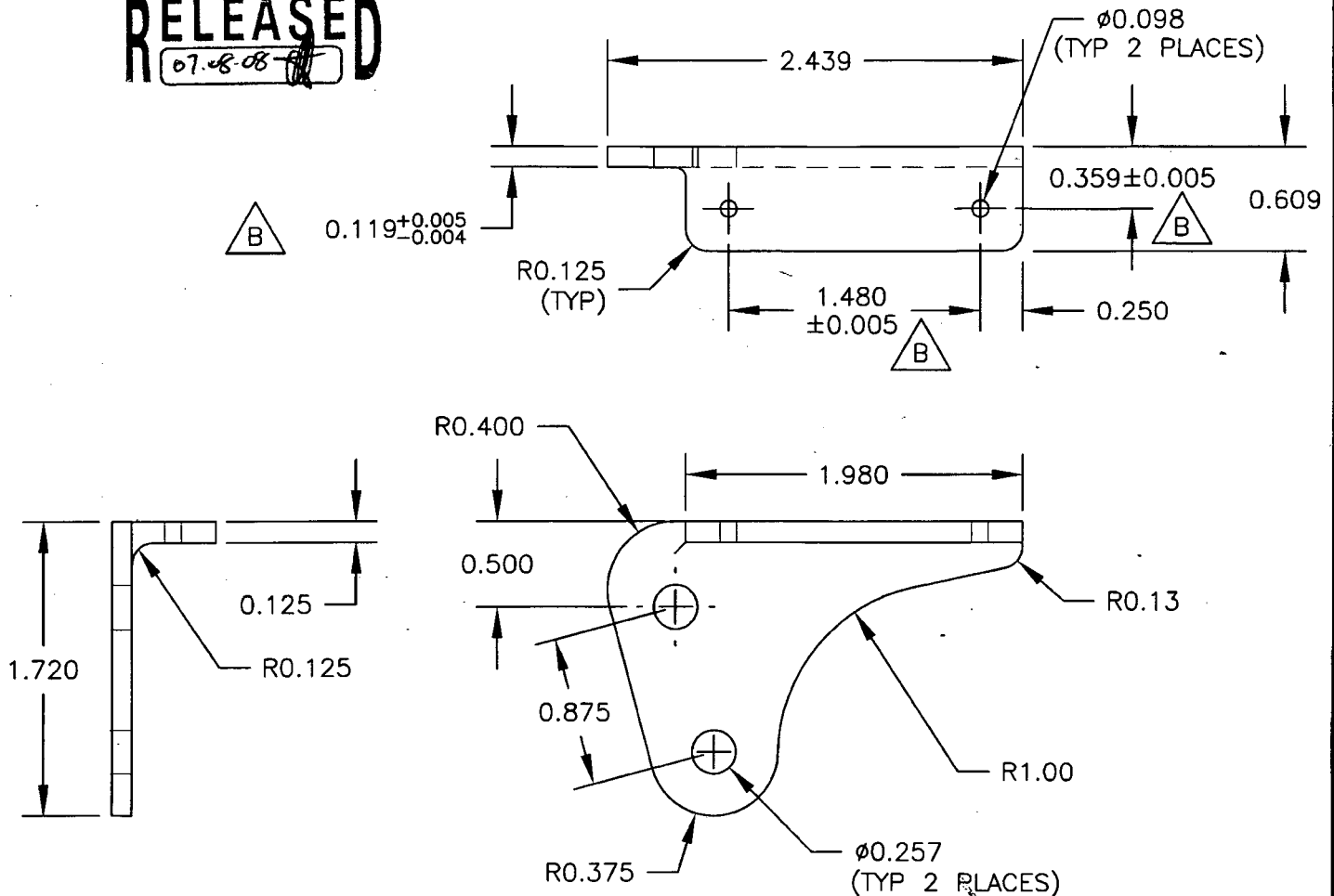
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NO. 45401A

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**DART**

DESIGN <i>qp</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>js</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

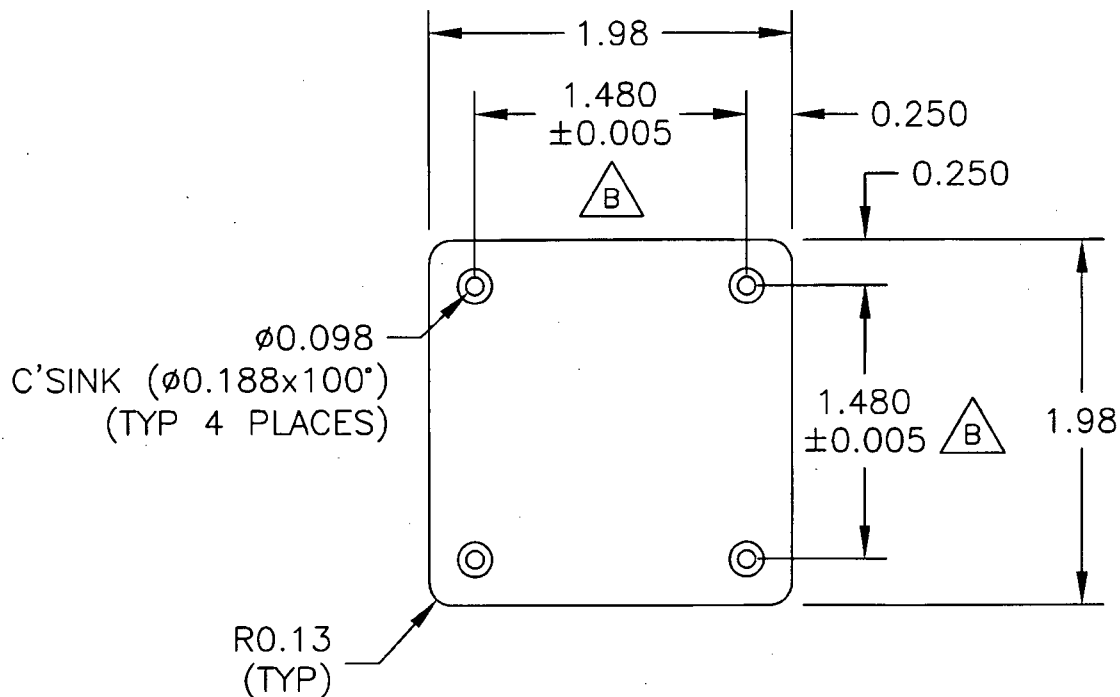
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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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